

5/44

DART AEROSPACE LTD	Work Order:	24267
Description: Bracket Assembly	Part Number:	D3121-144
Dwg: D3121 Rev. C	Qty:	3 14
		Page 1 of 1

FF
04.02.27

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveler Dwg not required	AB	05.09.14	3																
2	MV	Cut blank: (1.000" x 2.000") 4.425" long Material: 17-4 SS Bar per AMS 5604/5643 (M17-4-B1.000x02.000) Identify for D3121-114 Batch: <u>M14539</u>	AB	05/09/14	3																
3	MV	Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114	AB	05.10.08	3																
4	QC2	Inspect parts as they come off the CNC machine	AB	05.10.08	3																
5	MV	Deburr	AB	05.10.08	3																
6	MV	Scribe batch number	AB	05.10.08	3																
7	QC8	Second check	SD	05.10.09	3																
8	GA	Assemble D3121-144 as per Dwg D3121. Pick: <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>D3121-21</td><td>Bolt</td><td>B244953</td></tr><tr><td>2</td><td>D3121-241</td><td>Bearing Assembly</td><td>1323914</td></tr><tr><td></td><td></td><td></td><td>1324282</td></tr></tbody></table> Identify as D3121-144	Qty	Part Number	Description	Batch	2	D3121-21	Bolt	B244953	2	D3121-241	Bearing Assembly	1323914				1324282	AB	05/10/17	3
Qty	Part Number	Description	Batch																		
2	D3121-21	Bolt	B244953																		
2	D3121-241	Bearing Assembly	1323914																		
			1324282																		
9	QC5	Inspect work to Step 8	AB	05/10/17	3																
10	ST	Identify and Stock	AB	05/10/19	3																
11	AC	Cost / part	AB	05-12-02	3																
12	DC	Close W/O Inspect Level 21																			

ADJ 260

ADJ 266

Rev	Date	Change	Revised By	Approved
AB	04.02.18	New issue	KJ/DS	

FF 04.02.19

RELEASED
04.02.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order: 24267
Description: Bracket		Part Number: D3121-114
Inspection Dwg: D3121	Rev: C2	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.080	✓			
0.300	+/-0.010	.298	✓			
R0.375	+/-0.010	.375	✓			
1.54	+/-0.030	1.541	✓			
0.350	+/-0.010	.352	✓			
R0.250	+/-0.010	.250	✓			
1.800	+/-0.030	1.805	✓			
Ø0.392	+0.002/-0.000	.392	✓			To fit bearing
Ø0.201	+0.005/-0.000	.201	✓			
0.100	+/-0.010	.100	✓			
2.540	+/-0.010	2.540	✓			
1.590	+/-0.010	1.590	✓			
0.160	+/-0.010	.160	✓			
0.400	+/-0.010	.399	✓			
1.220	+/-0.010	1.220	✓			
1.600	+/-0.010	1.606	✓			
3.80	+/-0.030	3.800	✓			
1.800	+/-0.010	1.805	✓			
R0.500	+/-0.010	.500	✓			
0.130	+/-0.010	.132	✓			
3.41	+/-0.030	3.40	✓			
3.65	+/-0.030	3.630	✓			
2.24	+/-0.030	2.210	✓			
45°	+/-0.1°	45°	✓			
R0.250	+/-0.010	.250	✓			
3.97	+/-0.030	3.970	✓			
R0.38	+/-0.030	.375	✓			
Ø0.392	+0.002/-0.000	.392	✓			To fit bearing
Ø0.201	+0.005/-0.000	.201	✓			
0.100	+/-0.010	.100	✓			
0.268	+/-0.010	.268	✓			
R0.260	+/-0.010	.260	✓			
0.080	+/-0.010	.080	✓			
0.300	+/-0.010	.300	✓			

RELEASED

1/11/05.06

